

Work Order ID 158221

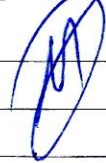
Wednesday, March 15, 2017 4:03:59 PM

158221

U/R

Page 1

Item ID: D4273-042 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: URF 16-640 **Stop *NS2***
Item Name: Basket Base Assembly, RH
Start Date: 3/30/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 4/6/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference: SCHEDULED

Approvals: **Process Plan:**  **Date:** MAR 16 2017 **Tooling:** **Date:** **Run Start *NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4273	E U/R
D4279	B

OK 4/13/16

100 Weld per dwg A/R S.S. rod Batch: 136158 0.00
Large Fab

100

Large Fab

Large Fab

Memo

3.16

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

APR 19 2017

DAS
24
9-89

★
PTO

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>158221</u> Part No. <u>D4273-042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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<u>Install qty (37) D4017-7 Ribs, to prevent warping.</u> DAS 12 9-89				<u>Acceptable.</u> <u>See PAR 16-551</u>				Completed By <u>DAS 24 9-89</u> <u>19 2017</u> Lead hand / Supervisor Approval Verification <u>DAS 9 9-89</u> <u>17.04.19</u> QC / QA Coordinator Approval <u>DAS 9 9-89</u> <u>17.04.19</u>																																																															
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158221

Page 2

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Revision ID:	URF 16-640	
Item Name:	Basket Base Assembly, RH	
Start Date:	3/30/2017	Start Qty
Required Date:	4/6/2017	Req'd Qty
Reference:	SCHEDULED	

Accept

N900040100

```
Setup Start *NS1*
Stop *NS2*
```

Start Date:	3/30/2017	Start Qty:	1.00	*1*
Required Date:	4/6/2017	Req'd Qty:	1.00	*1*
Reference:	SCHEDULED			

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

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Revision ID: URF 16-640 Stop ***NS2***
Item Name: Basket Base Assembly, RH
Start Date: 3/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130 Powdercoat Powder Coating	Memo <i>in B6657</i> 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: <i>3:30</i> START TIME: <i>3:30</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>4:00</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.64						<i>1 of 1704-19 34 38</i>	
140	QC3- Inspect Part Finish	0.00							
140 QC Quality Control	Memo	0.01							<i>1x of 17104120 15 88</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 158221

Wednesday, March 15, 2017 4:03:59 PM

158221

Page 4

Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-640 Stop ***NS2***
Item Name: Basket Base Assembly, RH
Start Date: 3/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>wlb</u>	0.00							
150									
Packaging	Memo	0.01							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

APR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Page 1

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC IPP Rev:B
11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03
AS PER DWG REV.D DD verf:EC IPP REV:D 12.07.24 AS PER
DWG REV.E DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4672-1 Blanking Plate		Manufactured	No			100	Each	15.0000	2	2			
** B153098 2x Cg 17-04-05													

Location

Loc Qty

Loc Code

WA004

15

153098

11

155254

4

✓ M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	536.5000	32	32			
** B137294 33 Cg 17-04-07													

Location

Loc Qty

Loc Code

WA004

536.5

M136951

33.5

M136991

503

✓ D3913-1 Rib		Manufactured	No			100	Each	0.0000	1	1			
** B157756 1x Cg 17-04-05													

✓ D3913-3 Rib		Manufactured	No			100	Each	8.0000	1	1			
** B146448 6x Cg 17-04-05													

Location

Loc Qty

Loc Code

WA004

8

146448

3

157564

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-9
D3913-9
Hinge Rib

Manufactured No

100

Each

8.0000

1

1

B146369 1x C 17-04-05

Location

Loc Qty

Loc Code

WA004

8

146369

2

155678

6

✓ D3916-5
D3916-5
Light Rib

Manufactured No

100

Each

9.0000

3

3

B157751 43x C 17-04-05

Location

Loc Qty

Loc Code

WA004

9

157560

9

✓ D4017-7
D4017-7
Rib

Manufactured No

100

Each

7.0000

1

1

B158198 3x C 17-04-05

Location

Loc Qty

Loc Code

WA004

7

152997

7

✓ D4277-3
D4277-3
Rib

Manufactured No

100

Each

2.0000

1

1

B157509 C 17-04-05

Location

Loc Qty

Loc Code

WA004

2

157509

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4277-5

Manufactured No

100

Each

4.0000

2

2

B157531 C 17-04-05

D4277-5

Rib

Location

Loc Qty

Loc Code

WA004

4

157531

4

D4277-9

Manufactured No

100

Each

5.0000

1

1

B146419 C 17-04-05

D4277-9

Rib

Location

Loc Qty

Loc Code

WA004

5

146419

5

D4277-19

Manufactured No

100

Each

3.0000

1

1

B151129 C 17-04-05

D4277-19

Rib

Location

Loc Qty

Loc Code

WA004

3

151129

3

D4278-041

Manufactured No

100

Each

0.0000

1

1

B157466 C 17-04-05

D4278-041

Upper Rib Assembly-Hoop

D4278-045

Manufactured No

100

Each

4.0000

2

2

B157557 C 17-04-05

D4278-045

Rib Assembly, Fwd Cham

Location

Loc Qty

Loc Code

WA004

4

157557

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

✓ J	D4278-047	Manufactured	No	100	Each	3.0000	1	1	**	B157034 1x Cp 17-04-05
	D4278-047									
	Upper Rib Assembly-Straight									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA004		3						
		151034		3						
✓ J	D4306-1	Manufactured	No	100	Each	5.0000	1	1	**	B156425 1x Cp 17-04-05
	D4306-1									
	Rib									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA004		5						
		146250		2						
		146425		3						
✓ J	D4306-044	Manufactured	No	100	Each	0.0000	1	1	**	B157460 1x Cp 17-04-05
	D4306-044									
	Rib Assembly, RH									
✓ J	D4306-045	Manufactured	No	100	Each	3.0000	1	1	**	B154041 1x 17-04-05
	D4306-045									
	Rib Assembly									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA004		3						
		144861		1						
		154041		2						
✓ J	D2581	Manufactured	No	100	Each	68.0000	2	2	**	B152803 2x Cp 17-04-05
	D2581									
	Mounting Bracket									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA004		68						
		152803		46						
		156869		22						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Page 5

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

D3913-15

Manufactured No

100

Each

23.0000

1

1

D3913-15

Wide Handle Plate

**

B153004 C 17-04-05

Location

Loc Qty

Loc Code

WA004

23

153004

2

153005

1

155768

1

157671

19

D4016-1

Manufactured No

100

Each

50.0000

3

3

D4016-1

Hinge Half, Base

**

B155346 C 17-04-05

Location

Loc Qty

Loc Code

WA004

50

154145

17

155346

33

D4021-1

Manufactured No

100

Each

50.0000

3

3

D4021-1

Handle Plate

**

B155731 C 17-04-05

Location

Loc Qty

Loc Code

WA004

50

151073

3

155731

16

157229

1

157523

30

D4279-5

Manufactured No

100

Each

3.0000

1

1

D4279-5

End Mesh, Basket

**

APR 18 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

WA006

3

142685

3

Wednesday, March 15, 2017 4:03:58 PM

Shop Packet Print

Page 5

157114

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, March 15, 2017 4:03:58 PM

Work Order ID: 158221

158221

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 3/30/2017

Required Date: 4/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4279-7

Manufactured No

100

Each

6.0000

2

2

APR 18 2017

**DAS
24
9-89**

D4279-7

End Mesh, Basket

Location

Loc Qty

Loc Code

WA006

6

142697

2

153983

2

154304

2

2

D4279-9

Manufactured No

100

Each

3.0000

1

1

APR 18 2017

**DAS
24
9-89**

D4279-9

End Mesh, Basket

Location

Loc Qty

Loc Code

WA004

1

131154

1

WA006

2

151140

2

1

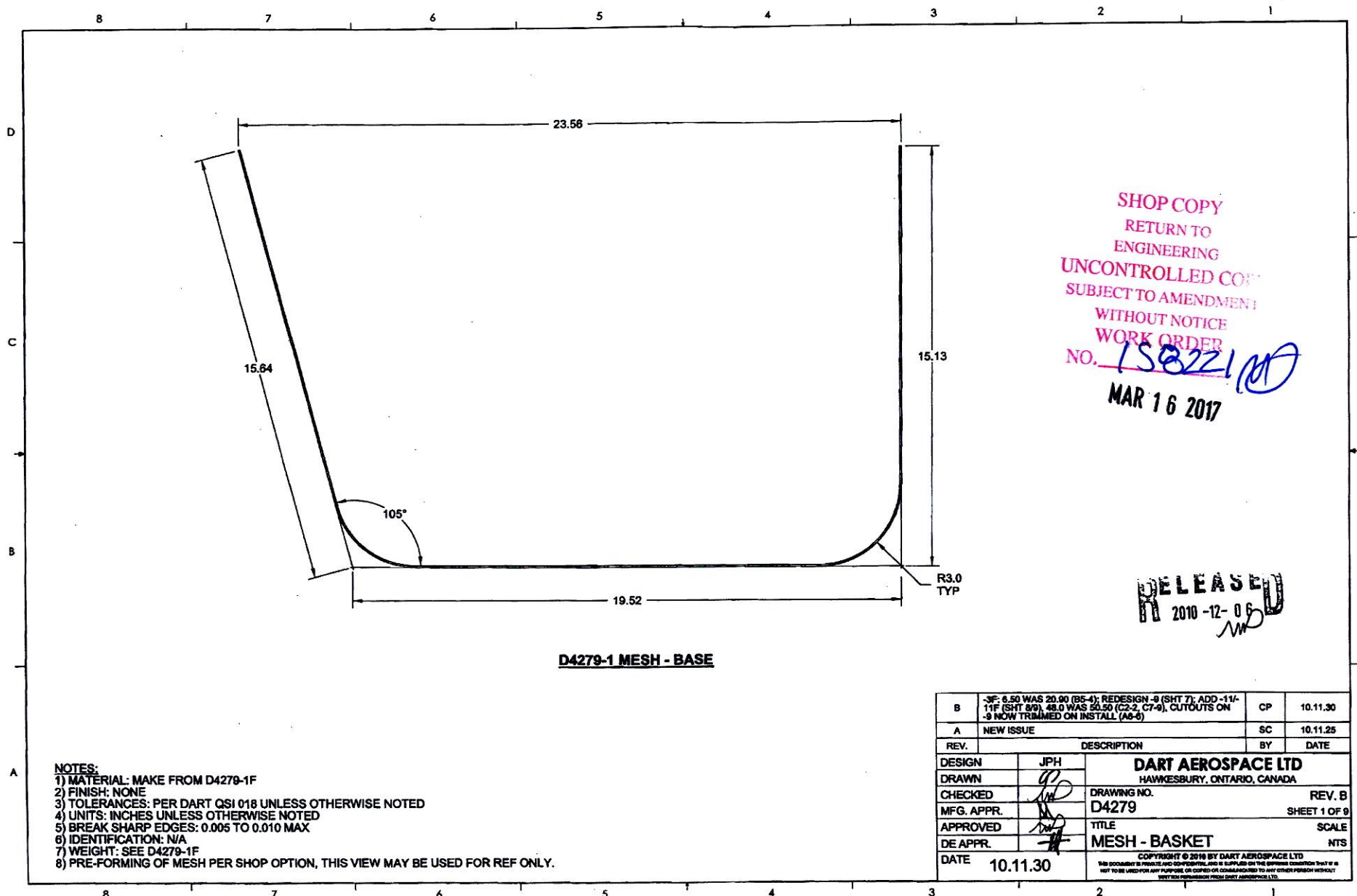
DQA: _____ Date: _____

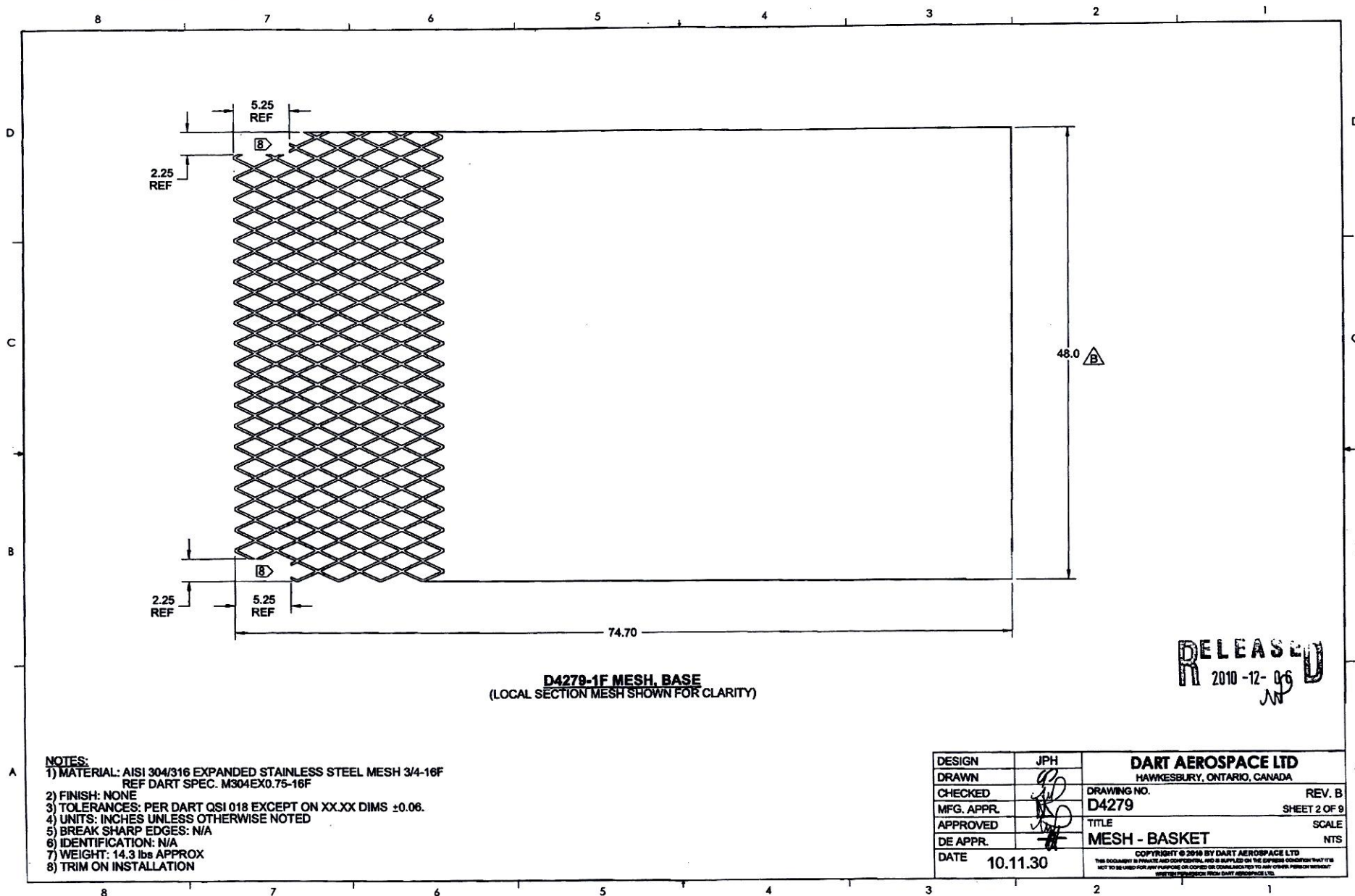
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

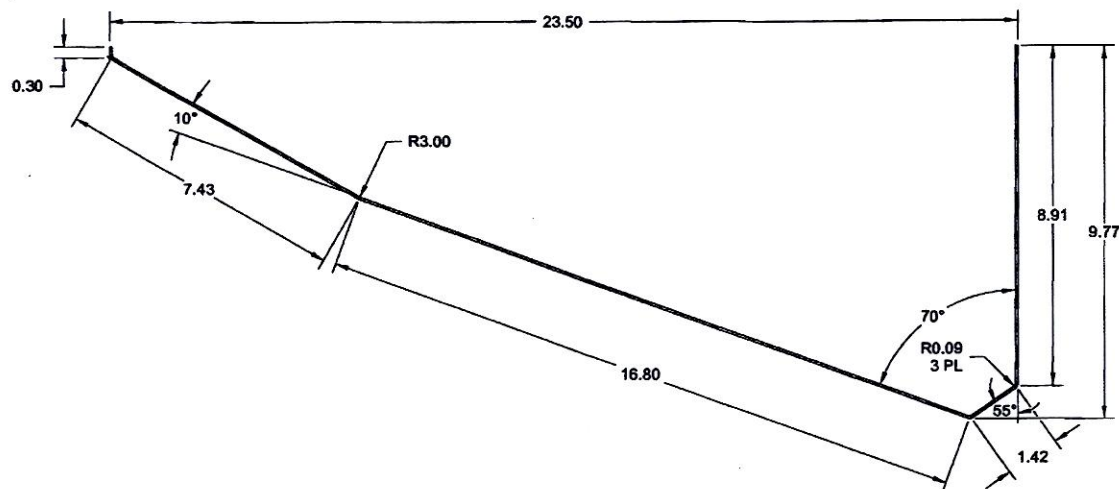
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																																																																									
Misidentified ☐	Past Due ☐																																																																										





NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.3 lbs APPROX
- 8) TRIM ON INSTALLATION



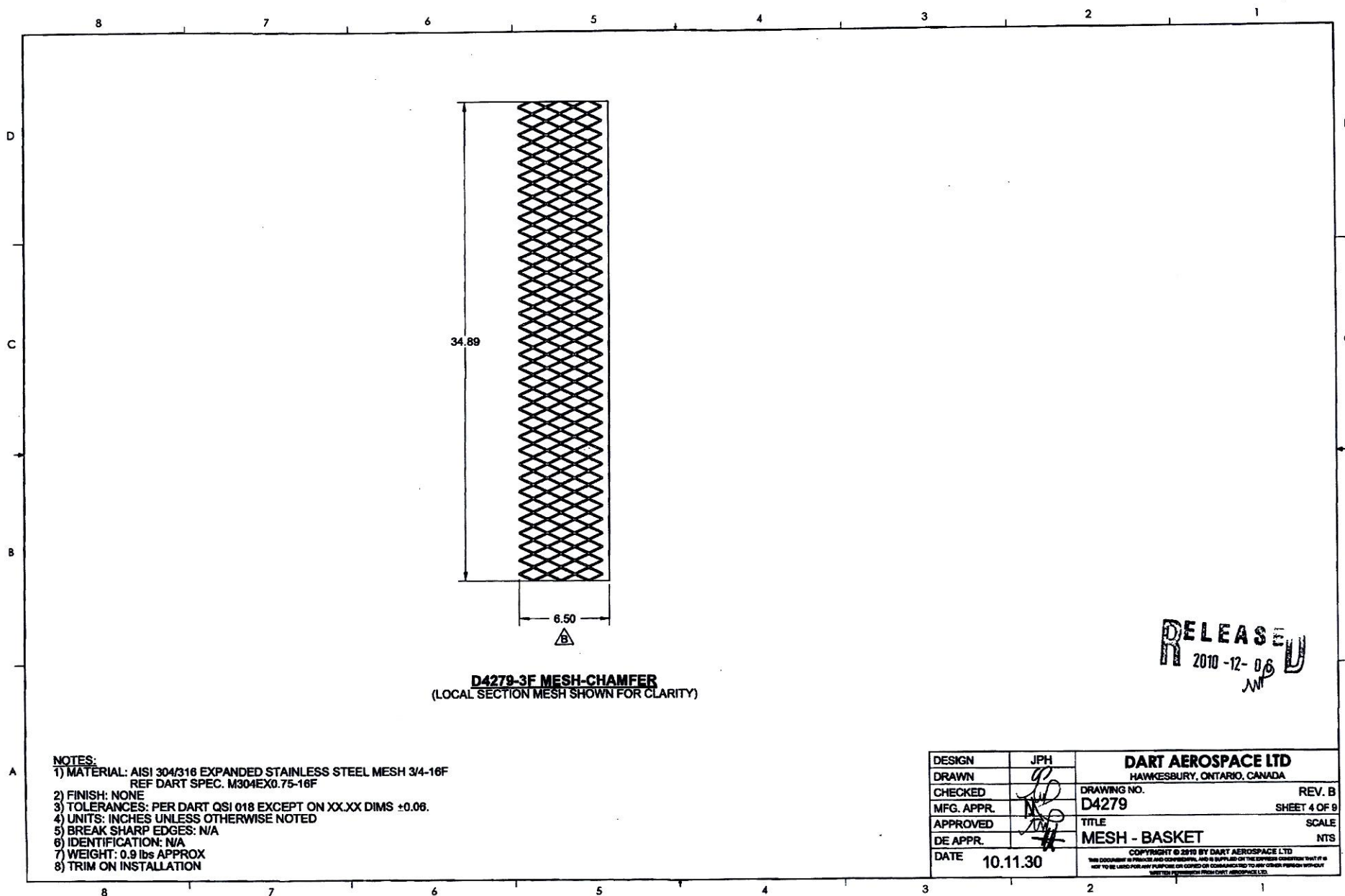
D4279-3 MESH-CHAMFER

RELEASED
2010-12-06

NOTES:

- 1) MATERIAL: MAKE FROM D4279-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-3F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 3 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
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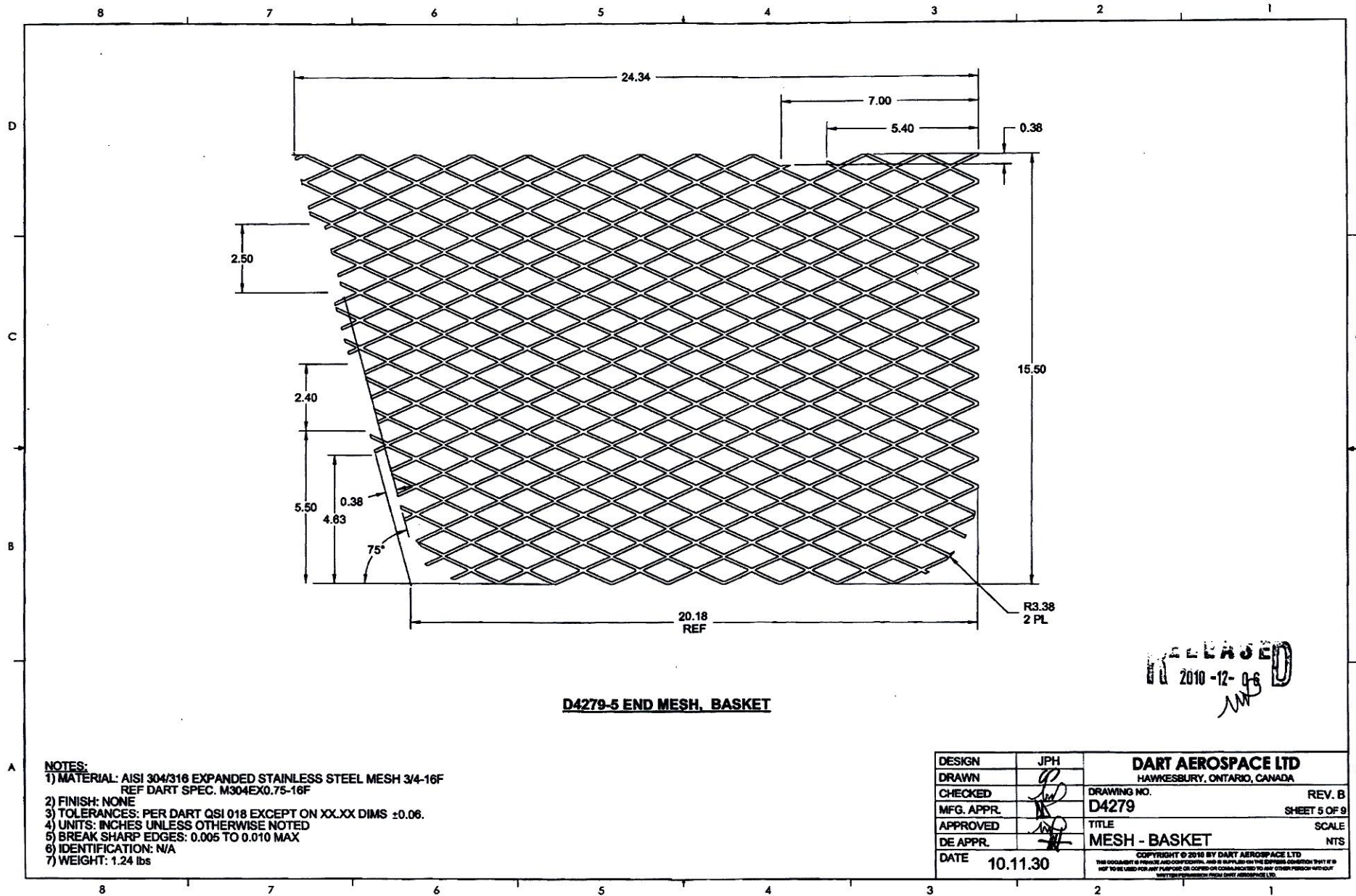


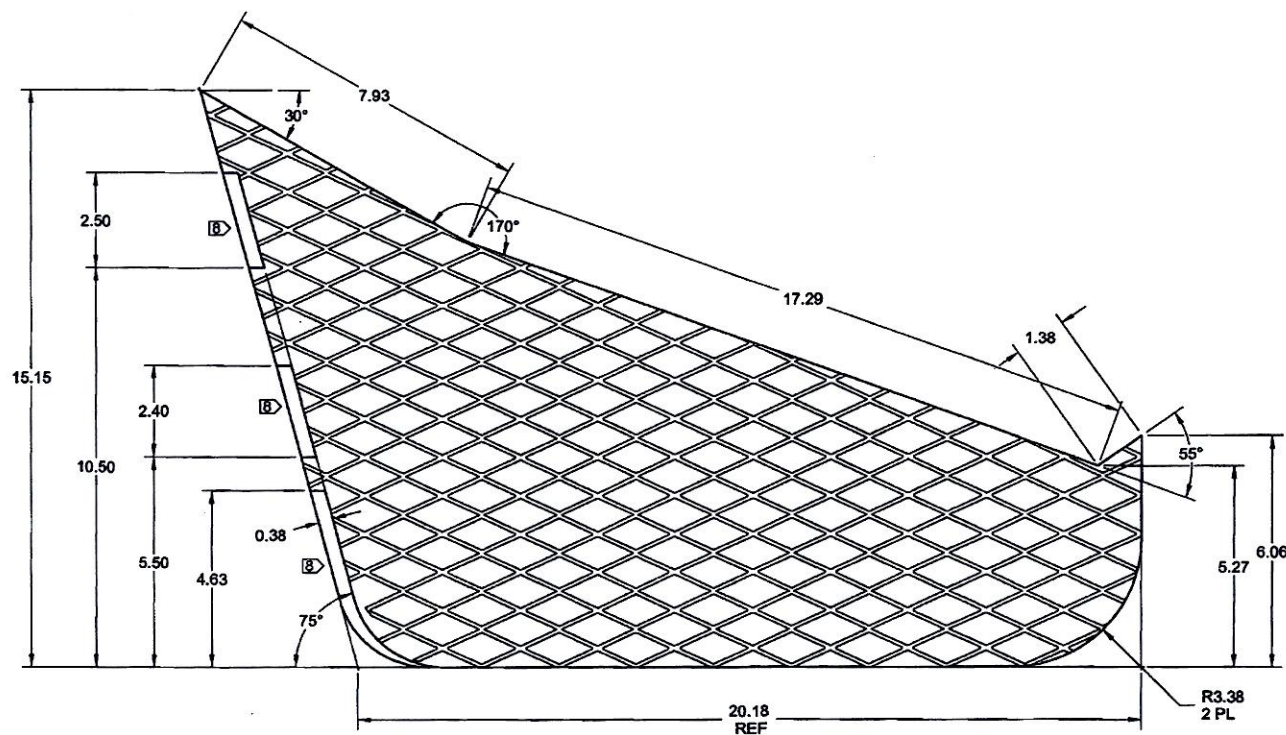
RELEASE
2010-12-06
MM

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4279	SHEET 4 OF 9
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	MESH - BASKET	NTS
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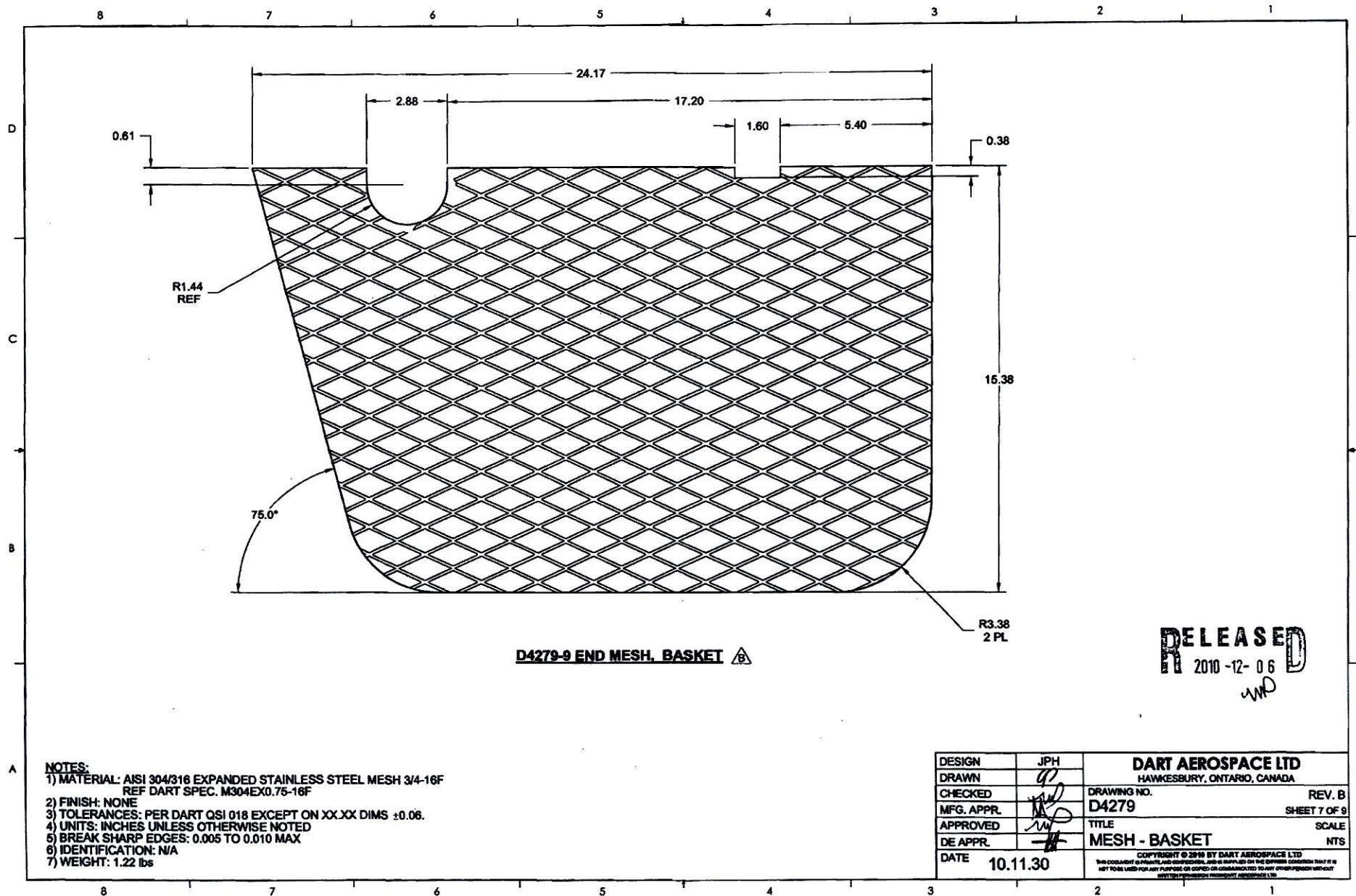
D4279-7 END MESH, BASKET

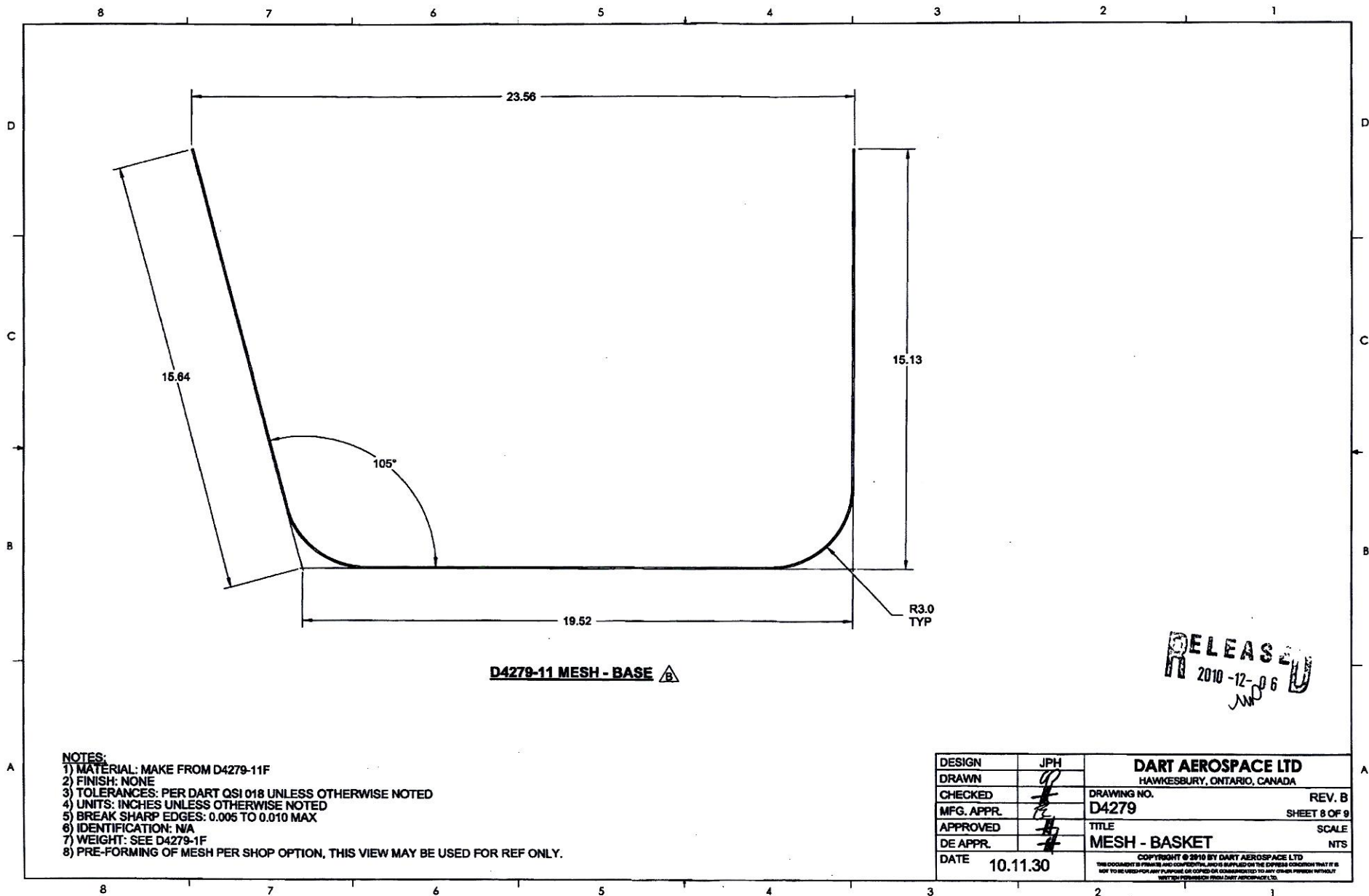
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2010-12-06
JW

NOTES:

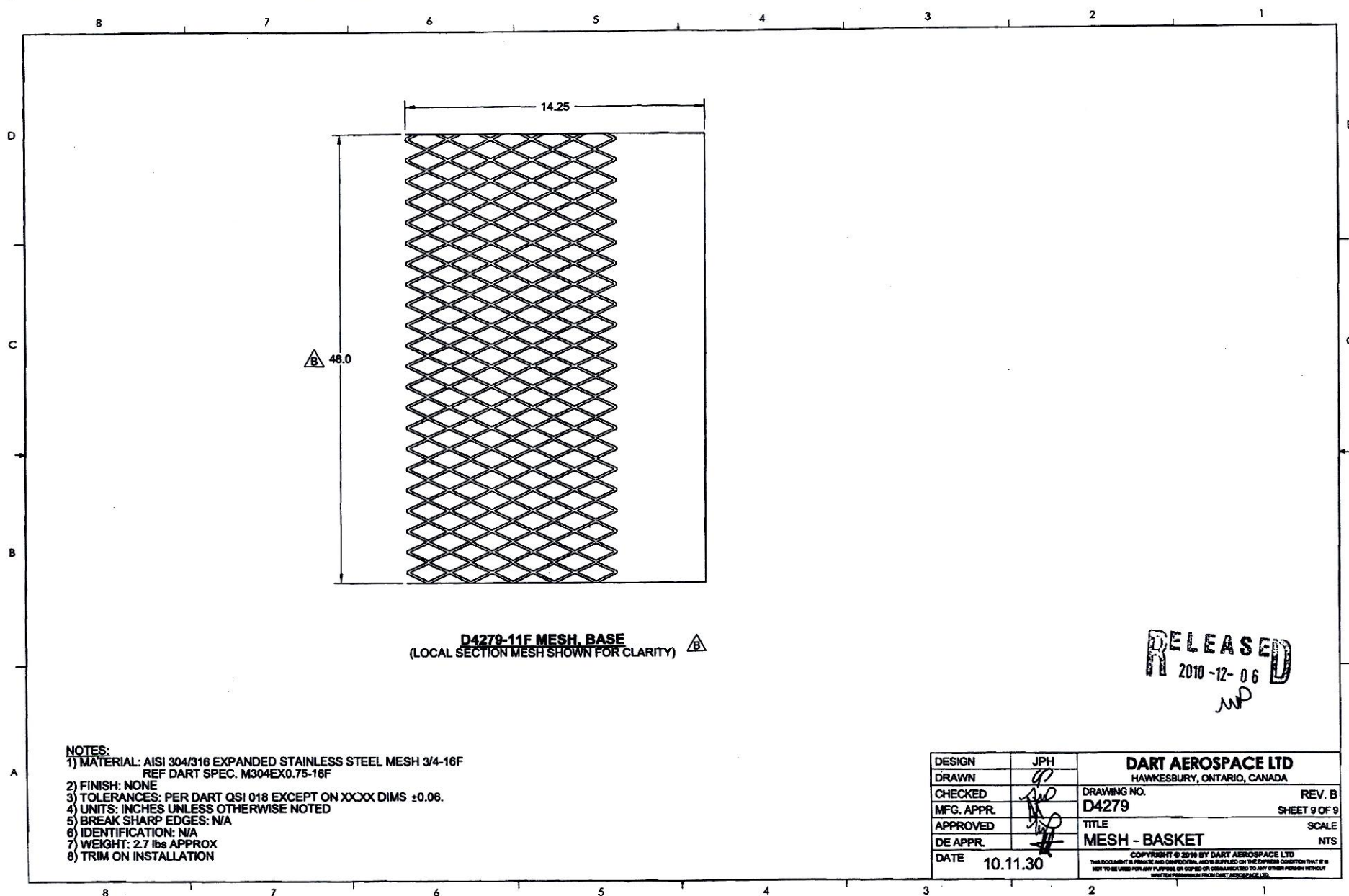
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs
- 8) TRIM ON INSTALLATION TO CLEAR HOLES (IF PRESENT)

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4279	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		MESH - BASKET	NTS
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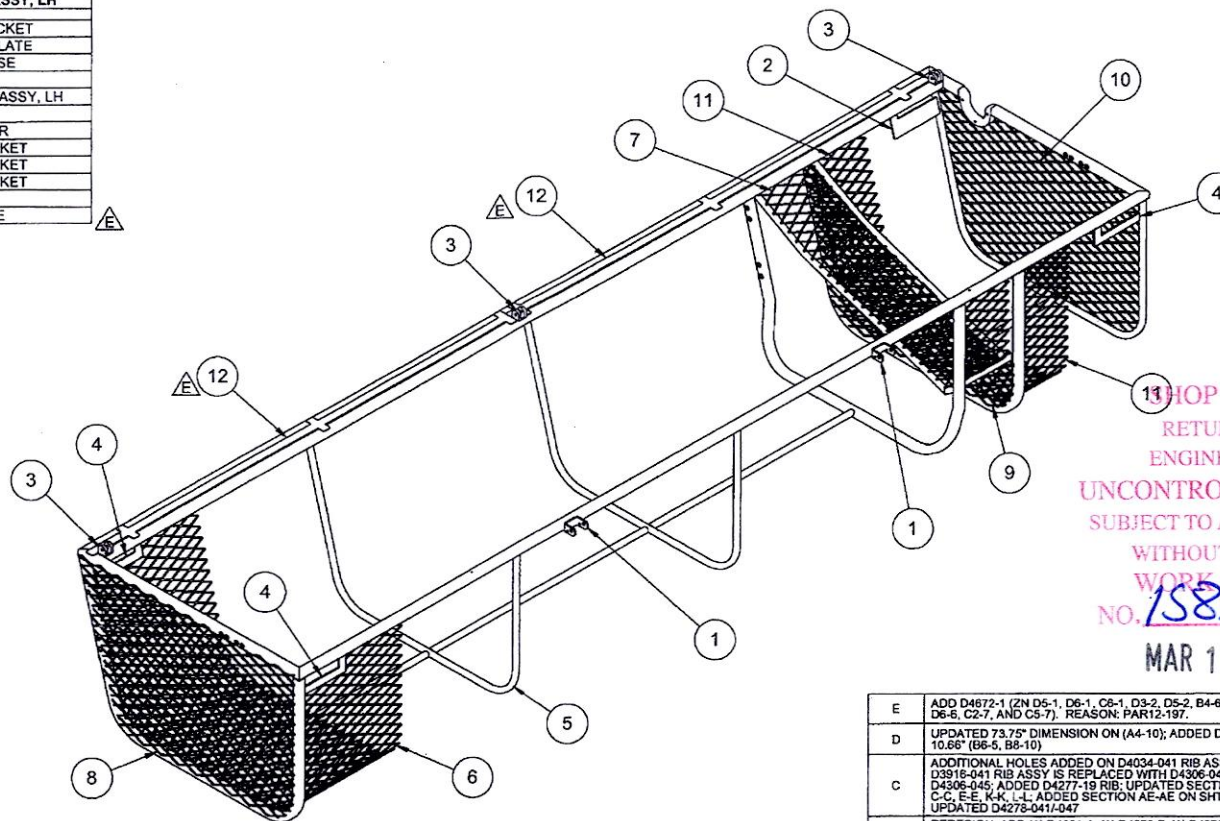




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 2010-12-06



ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

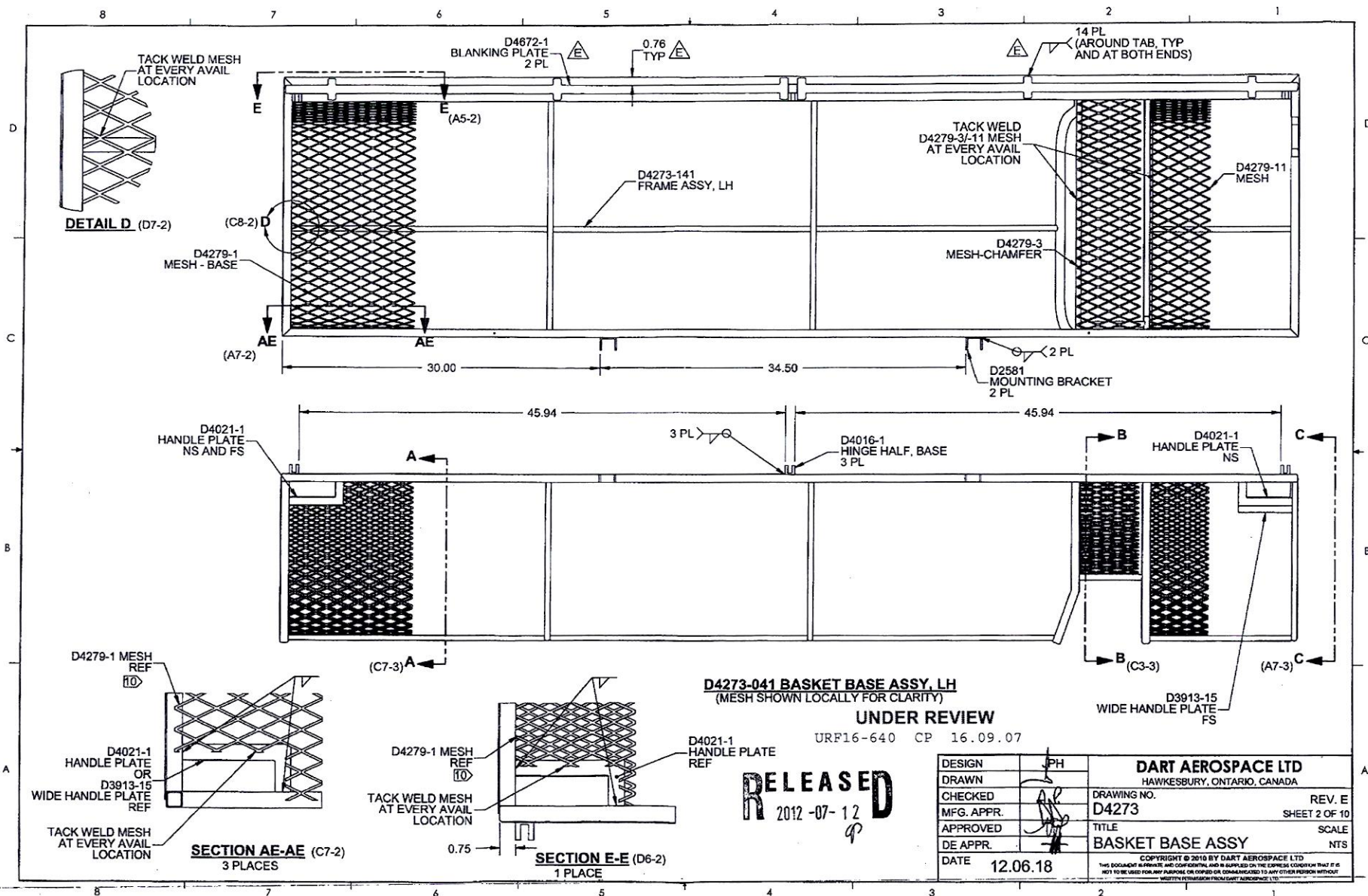
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URF16-640 CP 16.09.07

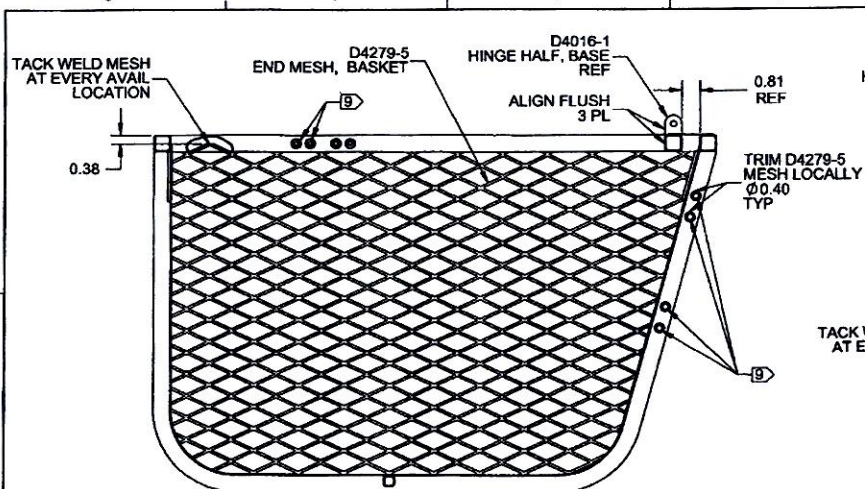
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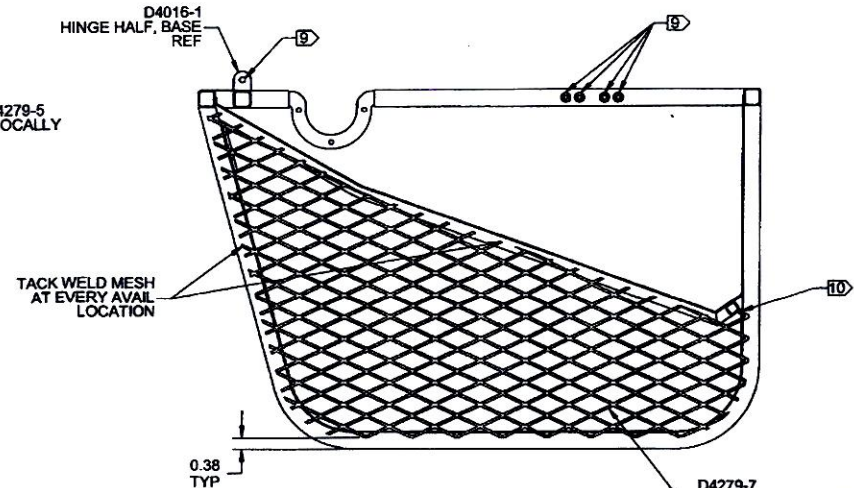
MAR 16 2017

E	ADD D4672-1 (2N D5-1, D6-1, C2-1, D3-2, D5-2, B4-6, C3-6, D6-8, C2-7, AND C3-7); REASON: PART 12.197.	MB	12.06.18
D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY: D3916-041 RIB ASSY IS REPLACED WITH D4306-043/-044 & D4306-045; ADDED D4277-19 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L, ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041/-047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-6); RMV D4277-17, D4278-043 (SHT 4.9); ADD (1) D3916-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-8), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JRH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4273 SHEET 1 OF 10 TITLE BASKET BASE ASSY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.18		

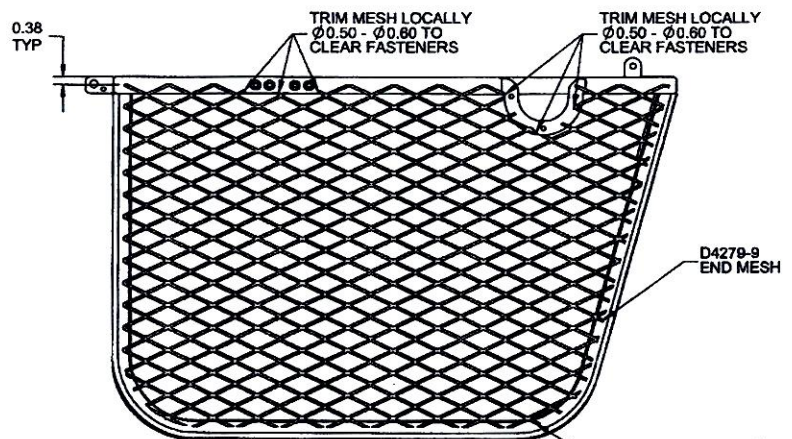




SECTION A-A (B6-2)



SECTION B-B (B2-2)
(MESH SHOWN LOCALLY FOR CLARITY)



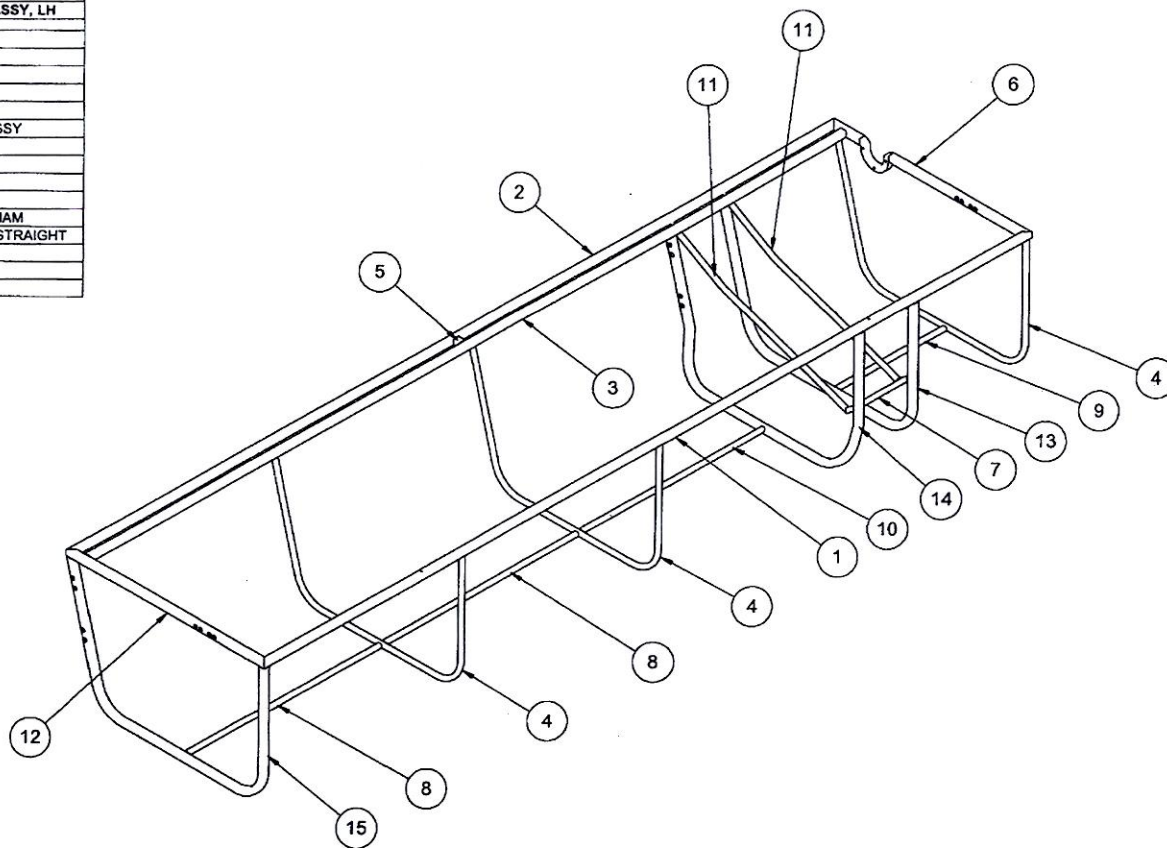
SECTION C-C (B1-2)
(MESH SHOWN LOCALLY FOR CLARITY)

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DESIGN	JRH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4273	REV. E
CHECKED			SHEET 3 OF 10
MFG. APPR.		TITLE BASKET BASE ASSY	SCALE NTS
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DATE	12.06.18		

ITEM	QTY -141	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY

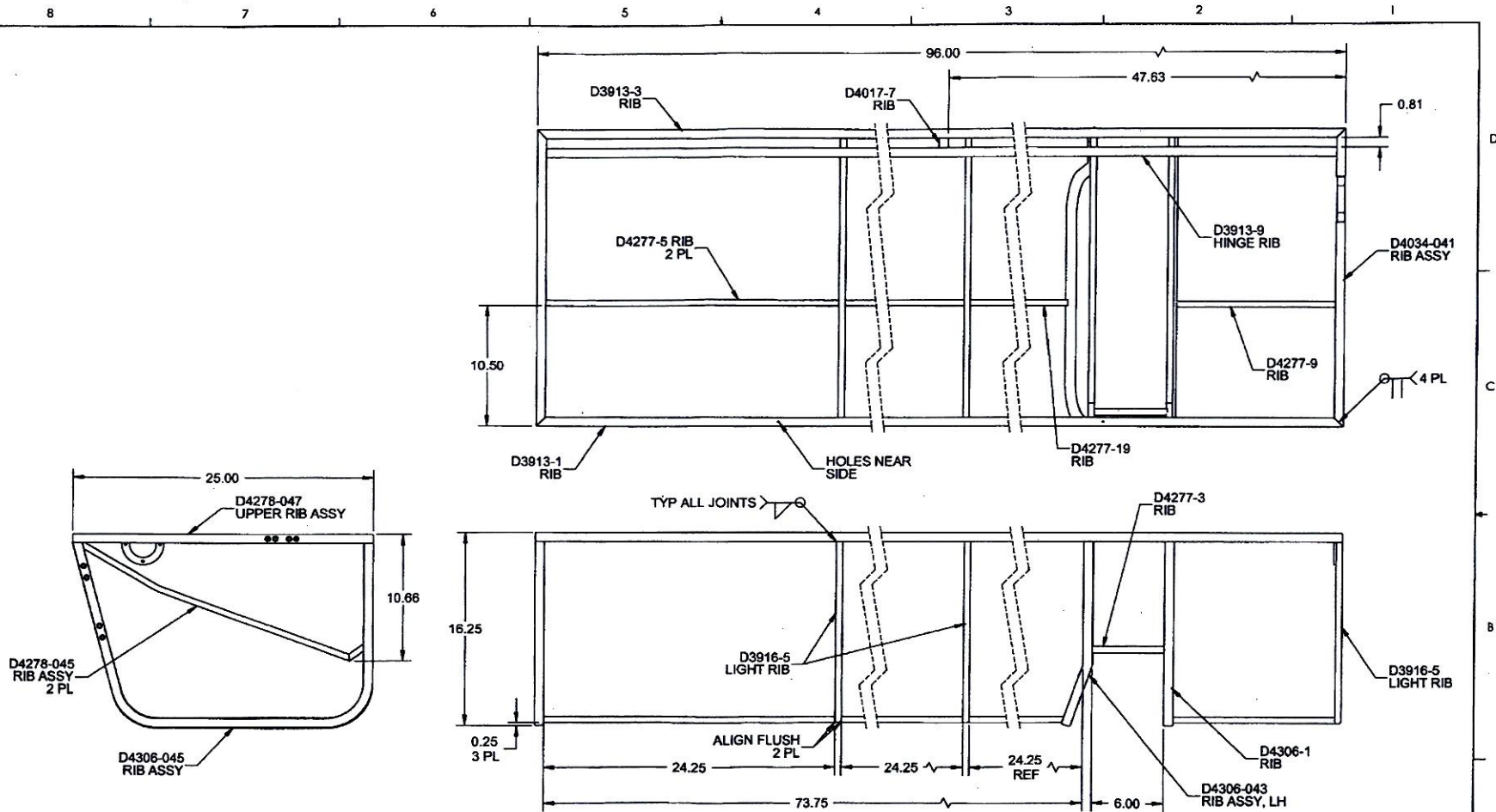


D4273-141 BASKET FRAME ASSY, LH

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URF16-640 CP 16.09.07

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DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	J.P.	DRAWING NO. D4273	REV. E
MFG. APPR.			SHEET 4 OF 10
APPROVED		TITLE BASKET BASE ASSY	SCALE
DE APPR.			NTS
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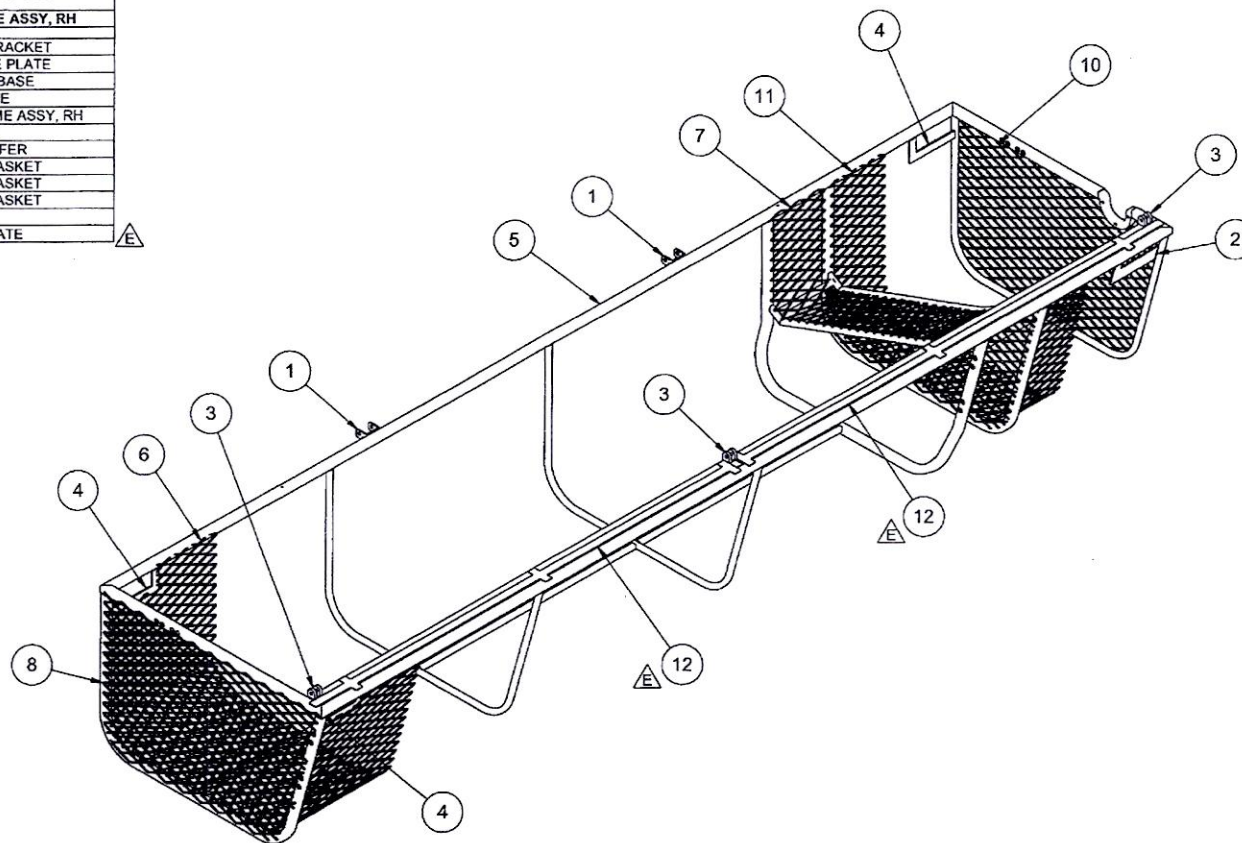
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 24.75 lbs
 - 8) WELD PER DART QSI 004

D4273-141 BASKET FRAME ASSY, LH
UNDER REVIEW
 URF16-640 CP 16.09.07

RELEASED
 2012-07-12
 UP

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED		D4273	SHEET 5 OF 10
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSY	NTS
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DATE	12.06.18		

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

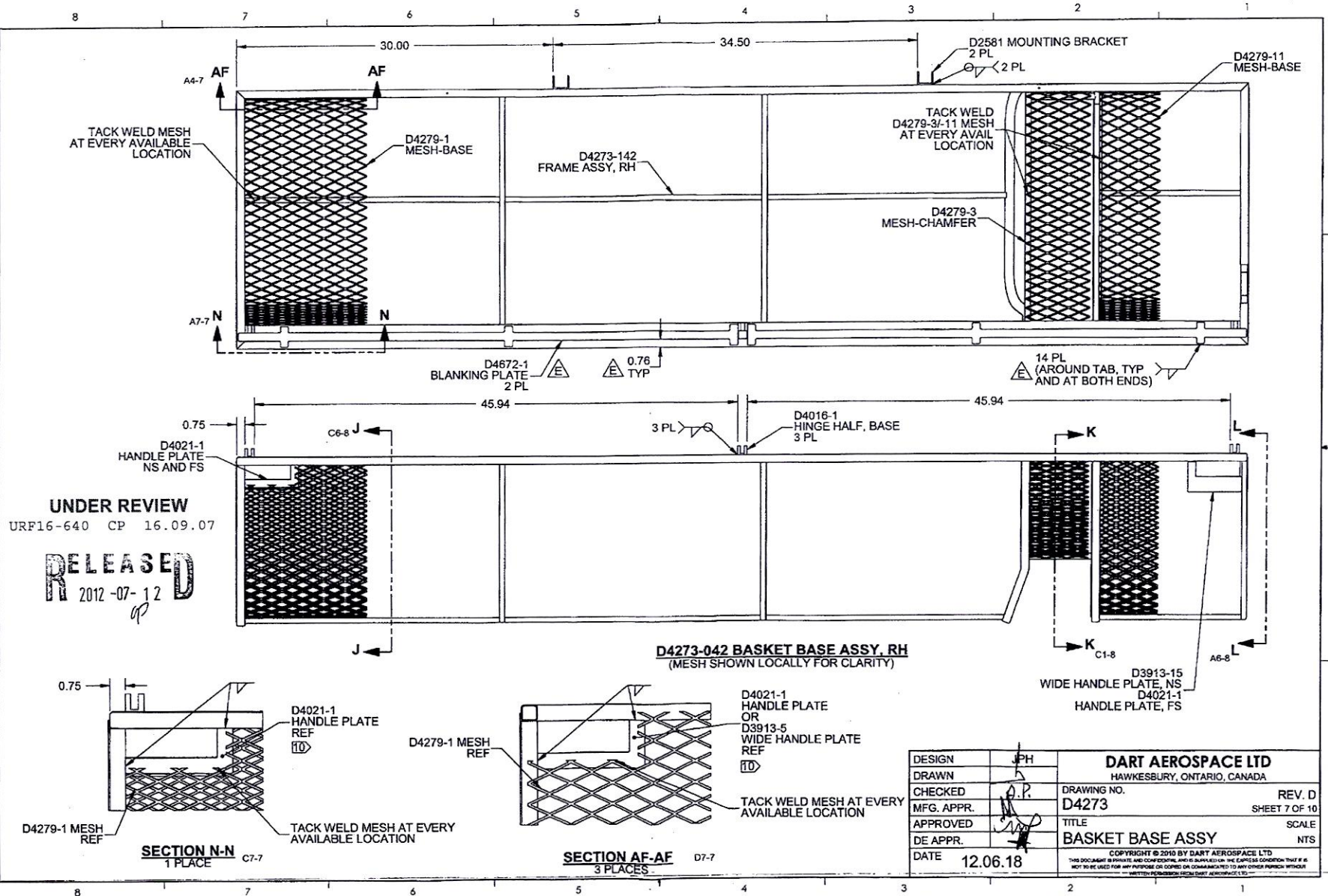
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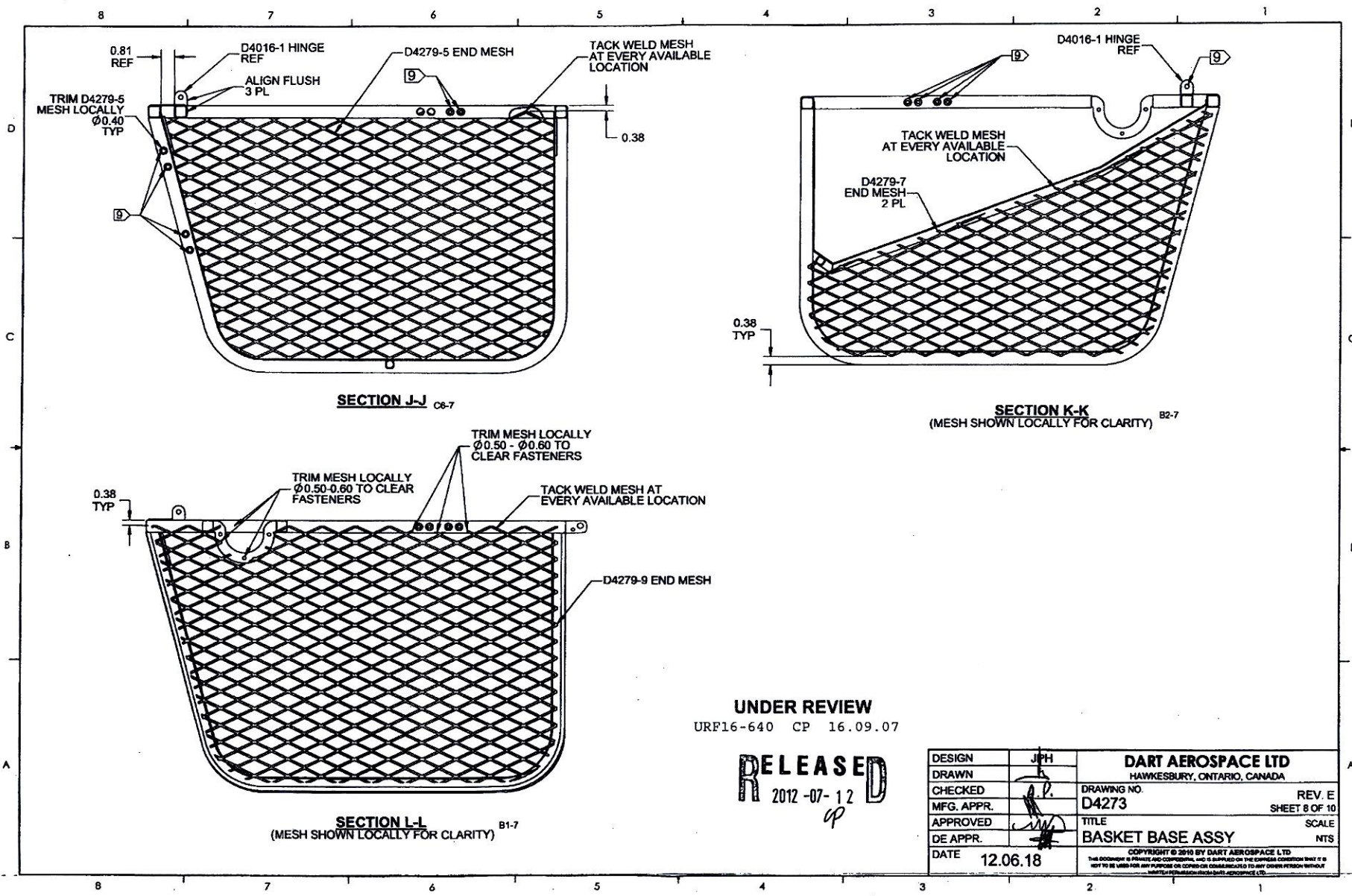
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

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URF16-640 CP 16.09.07

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DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4273	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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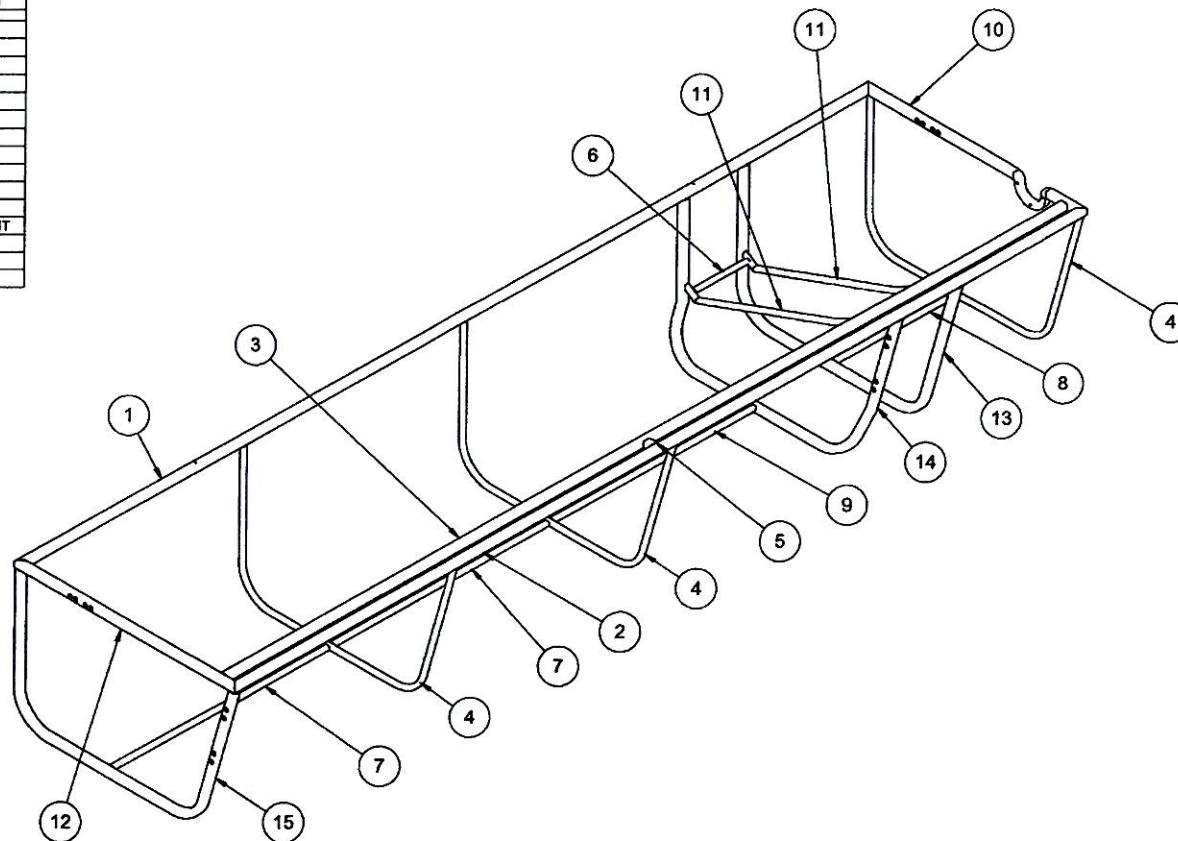


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DRAWN	JPH	DRAWING NO. D4273	REV. E
CHECKED	JPH		SHEET 8 OF 10
MFG. APPR.	JPH		SCALE
APPROVED	JPH	TITLE BASKET BASE ASSY	NTS
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DATE	12.06.18		

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY

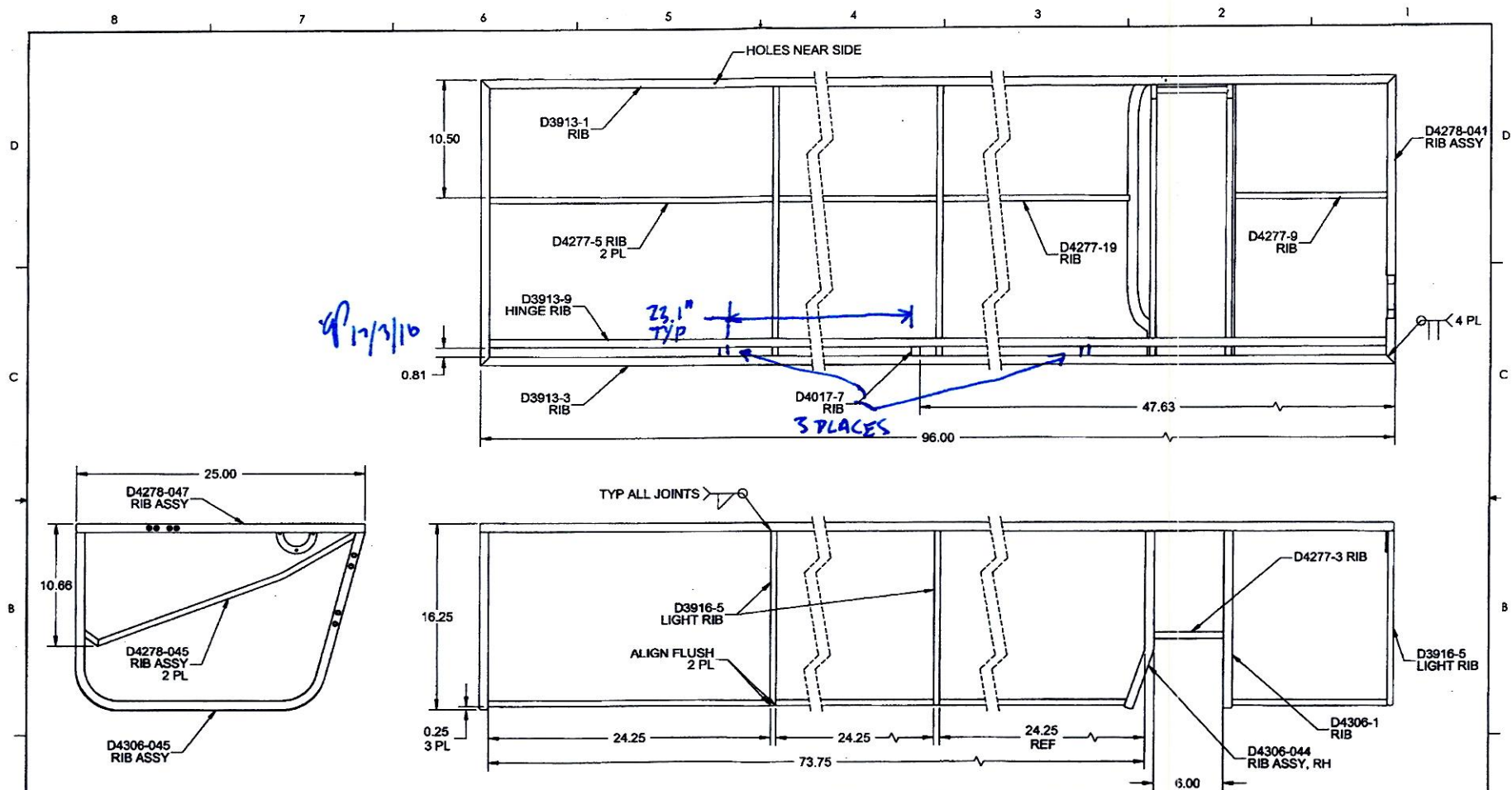


D4273-142 BASKET FRAME ASSY, RH

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2012-07-12
07

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4273	REV. E SHEET 9 OF 10
CHECKED		TITLE BASKET BASE ASSY	SCALE NTS
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APPROVED			
DE APPR.			
DATE	12.06.18		



D4273-142 BASKET FRAME ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.77 lbs
- 8) WELD PER DART QSI 004

UNDER REVIEW
URF16-640 CP 16.09.07

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DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4273	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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